AMENDMENTS TO THE CLAIMS

1. (Currently Amended) A process for producing a multilayer sheet S by coating an optionally pretreated carrier sheet with

~~1.~~ a pigmented basecoat film,

~~2.~~ if desired, a second pigmented basecoat film, and

~~3.~~ a clearcoat ~~film~~film,

~~characterized in that~~ the process comprising:

a. applying a pigmented basecoat material ~~is applied~~ to the carrier sheet to give a wet basecoat film 1a, and adjusting the basecoat film 1a ~~which is adjusted~~ to a residual volatiles content "x" ~~of x <~~ of less than 10% by weight, based on the basecoat film, to give a conditioned basecoat film 1b,

b. adjusting a surface of the ~~the assembly comprising carrier sheet and~~ conditioned basecoat film 1b ~~is adjusted~~ to a temperature ~~of < 50°C on the~~ of less than 50°C, to give a temperature-adjusted basedcoat film 1b~~surface of the basecoat film 1b~~,

c. if desired, applying a second pigmented basecoat ~~material,~~ material or the ~~same~~ pigmented basecoat material ~~for the second time, is applied~~ to the ~~conditioned and~~ temperature-adjusted basecoat film 1b to give a wet basecoat film 2a, and adjusting the basecoat film 2a ~~which is adjusted~~ to a residual volatiles content ~~of y <~~ "y" of less than 10% by weight, based on the basecoat film, to give a conditioned basecoat film 2b,

d. if appropriate, adjusting the ~~assembly comprising carrier sheet and~~ conditioned basecoat films 1b and 2b ~~is adjusted~~ to a ~~temperature of <~~ temperature of less than 50°C at ~~the surface~~ a surface of the basecoat film 2b, to give a temperature-adjusted basedcoat film 2b,

e. applying a clearcoat material ~~is applied~~ to the ~~conditioned and~~ temperature-adjusted basecoat film 1b or 2b to give a wet clearcoat film 3a, adjusting the clearcoat film 3a ~~which is adjusted~~ to a residual volatiles content ~~of z <~~ "z" of less than 5% by weight, based on the clearcoat film, to give a conditioned, deformable clearcoat film 3b, and curing the conditioned, deformable clearcoat film 3b ~~which is curable~~ thermally and/or with actinic radiation.

2. (Currently Amended) The process as claimed in Claim 1, ~~characterized in that~~ wherein the residual volatiles content in steps a., c. and/or e. is adjusted by heating and/or convection.

3. (Currently Amended) The process as claimed in ~~Claim 1 or 2~~ Claim 1, ~~characterized in that in~~ step a. further comprising

in the first drying section, employing an average drying rate of 10 to 40% by weight/min ~~is employed~~, based on the total volatiles content of the applied basecoat film, ~~until a~~ until the residual volatiles content x is ~~of x = 12~~ 12 to 30% by weight, based on the basecoat film~~, is reached~~, and

in the last drying section, employing an average drying rate of 1 to 6% by weight/min ~~is employed~~, based on the total volatiles content of the applied basecoat film, ~~until a~~ until the residual volatiles content ~~of x <~~ x is less than 10% by weight, ~~more preferably < 7% by weight, in particular < 5% by weight,~~ based in each case on the basecoat film~~, is reached~~.

4. (Currently Amended) The process as claimed in ~~any one of Claims 1 to 3~~ Claim 1, ~~characterized in that~~ comprising adjusting the basecoat film 1b in step b. ~~is adjusted~~ to a ~~temperature <~~ temperature of less than 35°C at ~~its~~ the basecoat film 1b surface.

5. (Currently Amended) The process as claimed in Claim 1, wherein ~~any one of Claims 1 to 4, characterized in that in~~ step c. further comprises

in the first drying section, employing an average drying rate of 10 to 40% by weight/min ~~is employed~~, based on the total volatiles content of the applied basecoat film, ~~until a~~ until the residual volatiles content ~~of y =~~ y is 12 to 30% by weight, based on the basecoat film~~, is reached~~, and

in the last drying section, employing an average drying rate of 1.5 to 4% by weight/min ~~is employed~~, based on the total volatiles content of the applied basecoat film, ~~until a~~ until the residual volatiles content ~~of x <~~ x is less than 10% by weight. ~~,~~

~~more preferably < 7% by weight, in particular < 5% by weight, based in each case on the basecoat film, is reached~~

6. (Currently Amended) The process as claimed in ~~either of Claims 1 and 5, characterized in that~~ Claim 1, comprising adjusting the basecoat film 2b in step d ~~is adjusted~~ to a temperature ~~of <~~ of less than 35°C at its surface 2b.

7. (Currently Amended) The process as claimed in ~~any one of Claims 1 to 6, characterized in that in~~ Claim 1, wherein step e. further comprises

in the first drying section, employing an average drying rate of 10 to 30% by weight/min ~~is employed~~, based on the total volatiles content of the applied clearcoat film, ~~until a~~ until the residual volatiles content ~~of z =~~ z is 10 to 15% by weight, based on the clearcoat film, ~~is reached,~~ and

in the last drying section, employing an average drying rate of 0.5 to 3% by weight/min ~~is employed~~, based on the total volatiles content of the applied clearcoat film, ~~until a~~ until the residual volatiles content ~~of z <~~ z is less than 7% by weight, ~~more preferably < 5% by weight, in particular < 3% by weight,~~ based in each case on the clearcoat film. ~~, is reached~~

8. (Currently Amended) The process as claimed in ~~any one of Claims 1 to 7, characterized in that the assembly comprising basecoat film 1b, if appropriate basecoat film 2b, and clearcoat film 3b is adjusted~~ Claim 1, further comprising, in a step f., adjusting a surface of the clearcoat film 3b to a ~~temperature <~~ temperature of less than 50°C ~~at the surface of the clearcoat film 3b~~.

9. (Currently Amended) The process as claimed in ~~any one of Claims 1 to 8, characterized in that the~~ Claim 1, further comprising covering a surface of the clearcoat film 3b with a protective sheet in a step g. ~~is covered with a protective sheet.~~

10. (Currently Amended) The process as claimed in ~~any one of Claims 1 to 9, characterized in that~~ Claim 1, wherein applying the basecoat material in step a. comprises applying ~~is applied~~ by means of a continuous method.

11. (Currently Amended) The process as claimed in ~~any one of Claims 1 to 10, characterized in that~~ Claim 1, wherein appying the basecoat material in step c. ~~is applied~~ comprises applying by means of a continuous method.

12. (Currently Amended) The process as claimed in ~~any one of claims 1 to 11, characterized in that~~ Claim 1, wherein applying the clearcoat material in step e. ~~is applied~~ comprises applying by means of a continuous method.

13. (Currently Amended) The process as claimed in ~~any one of Claims 1 to 12, characterized in that~~ Claim 1, wherein applying the basecoat material in step a. ~~is applied~~ comprises applying by means of a directed application method.

14. (Currently Amended) The process as claimed in ~~any one of Claims 1 to 13, characterized in that~~ Claim 1, wherein applying the basecoat material in step c. ~~is applied~~ comprises applying by means of an undirected application method.

15. (Currently Amended) The process as claimed in ~~any one of Claims 1 to 14, characterized in that the~~ Claim 1, further comprising wherein a free side of the carrier sheet has been covered with an adhesion coat.

16. (Currently Amended) The use of the multilayer sheets S produced by the process as claimed in ~~any one of Claims 1 to 15~~ Claim 1 for producing color and/or effect films.

17. (Currently Amended) The use as claimed in Claim 16, ~~characterized in that~~ wherein the color and/or effect films serve for the coating of substrates.

18. (Currently Amended) The use as claimed in ~~Claim 16 or 17, characterized in that~~ Claim 16, further comprising, after ~~they~~ the multilayer sheets S have been joined with ~~the~~ substrates, converting the multilayer sheets S into color and/or effect coatings ~~are converted~~ by thermal curing and/or curing with actinic radiation ~~into color and/or effect coatings~~.

19. (Currently Amended) The use as claimed in Claim 18, ~~characterized in that~~ further comprising stretching the multilayer sheets S ~~are stretched~~ before, during or after their joining to the substrates.

20. (Currently Amended) The use as claimed in ~~any one of Claims 17 to 19, characterized in that~~ Claim 17, wherein the substrates are selected from the group consisting of automobile bodies, ~~and~~ modules, and exterior mounted components therefore.

21. (New) The process as claimed in Claim 3, comprising, in the last drying section, employing an average drying rate of 1 to 6% by weight/min, based on the total volatiles content of the applied basecoat film, until the residual volatiles content x is less than 7% by weight.

22. (New) The process as claimed in Claim 21, comprising, in the last drying section, employing an average drying rate of 1 to 6% by weight/min, based on the total volatiles content of the applied basecoat film, until the residual volatiles content x is less than 5% by weight, based in each case on the basecoat film.

23. (New) The process as claimed in Claim 7, comprising, in the last drying section, employing an average drying rate of 0.5 to 3% by weight/min, based on the total volatiles content of the applied clearcoat film, until the residual volatiles content z is less than 5% by weight.

24. (New) The process as claimed in Claim 23, comprising, in the last drying section, employing an average drying rate of 0.5 to 3% by weight/min, based on the total volatiles content of the applied clearcoat film, until the residual volatiles content z is less than 3% by weight.